

Work Order ID 67038

Thursday, March 03, 2011 3:13:20 PM

Page 1

Item ID: D205-634-041

Accept

Revision ID:

Item Name: Replacement Skidtube

Start Date: 3/3/2011 Start Qty: 1.00

Required Date: 3/18/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: *M*Date: *11-03-3*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev.D DEO-D1

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG003

Subtotal

110

0.00



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo



0.00

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580







3- scribe batch# in aft end of tube

1 *REI/03/21**PTO A*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11.04.01	101	Reck D5951 SADDLE B/N 59445 D5953 SADDLE B/N 60934 ENLARGE FLANGE HOLES TO $\phi 0.328$	BE	11/04/01		 11.04.01		
11.04.01	102	Touch-up finish on D5951/D5953 sa saddles per PSI 005				 11.04.01 PSI 042		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.04.01	140	Fwd saddle holes are not aligned, saddle flange bolts will not install. Approx 0.020" of mis-alignment R.C. Process	 11.04.01 PSI 042	Add custom saddles to kit (see w/o CHG ABOVE) with enlarged flange holes	 11/01/4	 11/04/01	 11.04.01 PSI 042	 11/04/01
								

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
						1			
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for swaging as per QSI 002								
130	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

JB 4/03/22

DP 11-3-22

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004

A/R□□□ Aluminum Rod

M116577

BE 11/03/02

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

BE 11/04/01

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Quality Control

Memo

0.00

Sabellci

(20)

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd
cap out of solution.

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:00pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:30pm



P10
1st Pass

1 φ M 11/04/01

1 φ M 11/04/01

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Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

84124101

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 1116040

Sikaflex expire date: 11/09

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 1116040

Sikaflex expire date: 11/09

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 1116402

1 0 1116040

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041
Location: _____
PPP Rev: _____

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u 11.04/01

W/O:		WORK ORDER CHANGES					
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Thursday, March 03, 2011 3:13:32 PM

Page 1

Work Order ID: 67038

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 3/3/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
 KJ IPP Rev P 10.02.19
 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
 10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 Spacer		Manufactured	No			140	Each	247.0000	20	20			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>247</div> <div></div> </div>													
<div> <div>65529</div> <div>26</div> <div></div> </div>													
<div> <div>66121</div> <div>221</div> <div></div> </div>													
D2580-1 205 Skidtube bent detail		Manufactured	No			110	Each	6.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>6</div> <div></div> </div>													
<div> <div>59856</div> <div>1</div> <div></div> </div>													
<div> <div>65510</div> <div>4</div> <div></div> </div>													
<div> <div>65511</div> <div>1</div> <div></div> </div>													
D2576-3 Step (maching detail)		Manufactured	No			140	Each	40.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>40</div> <div></div> </div>													
<div> <div>52215</div> <div>40</div> <div></div> </div>													

BE 1/10/01
B67430 20

BE 1/03/21
B67073

BE 1/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 67038

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 3/3/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

91.0000

1

1



Cap

Location

Loc Qty

Loc Code

FP6

1

56613

1

fp7

15

65519

15

ST024

75

50513

1

50770

28

51539

2

53791

9

65569

35

X1

AN3-5A

Purchased

No

200

Each

711.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST350

711

115016

45

115371

500

116632

166

X2

AN960JD10L

~~NAS1149D03324~~

Purchased

No

200

Each

4.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST335

4

11912

4

X1 117010

V2

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 3/3/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130 Purchased No

200 Each

1,654.000 50 50



Insert

Location

Loc Qty

Loc Code

FP

21

115079

21

ST282

1633

111529

32

113238

17

115502

500

115581

84

116800

1000

AN3C4A Purchased No

200 Each

2,626.000 50 50



BOLT

Location

Loc Qty

Loc Code

ST350

2626

115300

25

116075

337

116704

564

116924

1200

117010

500

AN960C10L NAS1149C0332 Purchased No

200 Each

61.0000 50 50



washer

Location

Loc Qty

Loc Code

ST245

61

107534

59

108246

2

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Page 3

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Start Date: 3/3/2011

Required Date: 3/18/2011



Start Qty: 1.00

Required Qty: 1.00

D3566-13 Manufactured No 200 Each 64.0000 1 1
  11/04/01
 Gasket



Location Loc Qty Loc Code

FP011	36	
66550	36	X1
FP014	28	
64070	11	
66137	17	

D3566-5 Manufactured No 200 Each 43.0000 1 1
  11/04/01
 Gasket

Location Loc Qty Loc Code

FP015	43	B67579 X1
63574	1	
65528	13	
66146	9	
66552	20	

D3566-1 Manufactured No 200 Each 68.0000 2 2
  11/04/01
 Gasket

Location Loc Qty Loc Code

FP	20	B67579 X2
66548	20	
FP011	19	
65525	19	
FP015	29	
57715	1	
66040	20	
66129	8	

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Start Date: 3/3/2011


Required Date: 3/18/2011

Start Qty: 1.00


Required Qty: 1.00

D3564-11 Manufactured No 200 Each 22.0000 1 1

Wearshoe

Location	Loc Qty	Loc Code
FP019	22	366154
65159	8	
66554	14	

D3564-13 Manufactured No 200 Each 51.0000 1 1

Wearshoe

Location	Loc Qty	Loc Code
FP16	28	
65522	10	
66549	18	
FP17	23	
59660	1	
66136	22	

D3564-9 Manufactured No 200 Each 23.0000 1 1

Wearshoe

Location	Loc Qty	Loc Code
FP	1	
55334	1	
FP019	20	
66153	20	
FP19	2	
62238	2	

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Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

47.0000

1

1



Wearshoe



HL 1104101

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

24

57525

1

58709

1

66551

22

VL

FP-19

22

63575

1

65523

6

66148

15

D2594-3

Manufactured No

200

Each

1,015.000

16

16



O-Ring, 205 Skidtube



HL 1104101

Location

Loc Qty

Loc Code

FP

543

55546

19

58191

12

59358

12

65518

500

VL

fpa

472

61762

472

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Start Date: 3/3/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured

No

200

Each

744.0000

16

16



Plug, 205 Skidtube



21 11/04/01

Location

Loc Qty

Loc Code

FP	483
42807	112
55002	71
<u>66122</u>	300
FP14	261
58434	15
65512	133
65980	113

<u>✓ 16</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.06.28 #**DEO ATTACHED**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *117638*

0711-033

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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07-06-28

DEO ATTACHED

Technical drawing of a circular base plate with a central hole and a rectangular slot. The drawing includes the following dimensions and callouts:

- Dimensions:**
 - 60.208 (Overall diameter)
 - 0.40 (Slot width)
- Callouts:**
 - DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
 - AN3-5A BOLT (1)
 - AN960JD10L WASHER (1)
 - (2 PLACES)
 - D2855 CAP
 - SEAL WITH SIKAFLEX-241/-291

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)
(TYP 50 PLACES)

AFTER PERFORM
1. CHA
2. INSU
3. WEL
4. C'B'

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO $\phi 0.437$ X 1.00 DEEP

37.50
DISTANCE TO AFT END
OF D2596 WEB
3
7
REFER TO DETAIL A
1.750
1.750
0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)

Figure 1 illustrates the typical cross-section of a road with a 4% grade. The diagram shows a road profile with a 4% upward slope. Key dimensions include a 1.4m vertical offset at the start, a 13.4m horizontal distance from the start to the first hole, and a 1.0m distance between the hole and the tangent point. A second hole is located 32.0 ± 1.0m from the tangent point, with a 20.0m vertical offset and a 0.640m radius of curvature indicated.

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

0.5

1.5

1.5

0

P

P

P

P

P

P

P

1.5

1.5

1.5

REFER TO DETAIL C

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

AN960C10L WASHER (1)





(50 PLACES)

DESIGN

DRAWN BY

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN		DRAWN BY	
CHECKED		APPROVED	
DATE			
07.02.27			

DART		DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA	
DRAWING NO. D2580		REV. SHEET 2 OF 2	
TITLE 205 SKIDTUBE ASSEMBLY		SCALE AS SHOWN	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

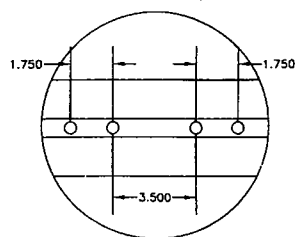
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

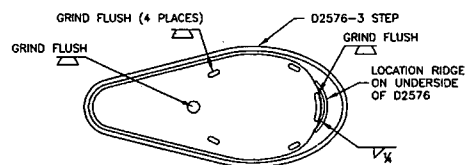
NOTE: Date & initial all entries

DETAIL E
SCALE 5:24



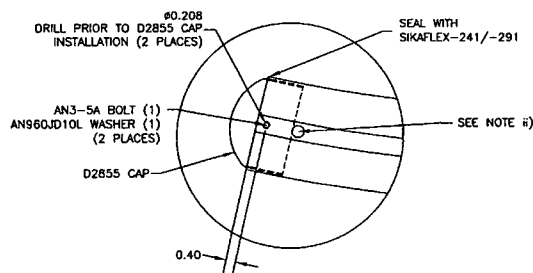
RELEASED
07-06-18

DETAIL F
SCALE 5:24

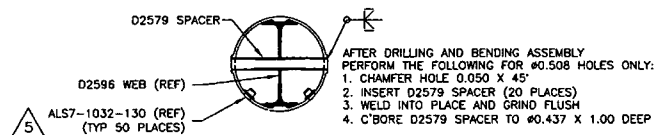


DEO ATTACHED

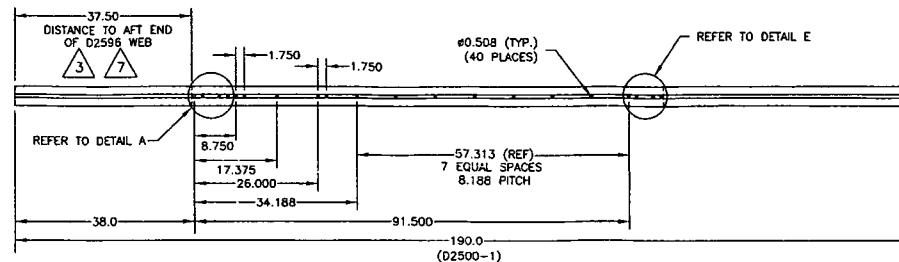
DETAIL G
SCALE 5:24



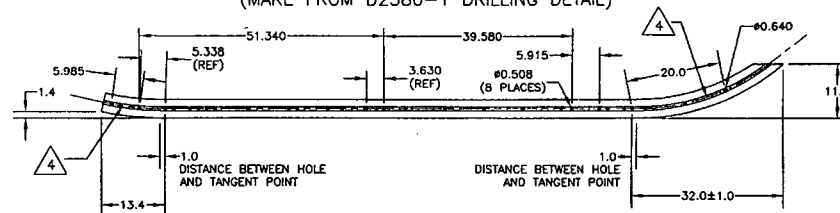
SECTION H-H
SCALE 5:24



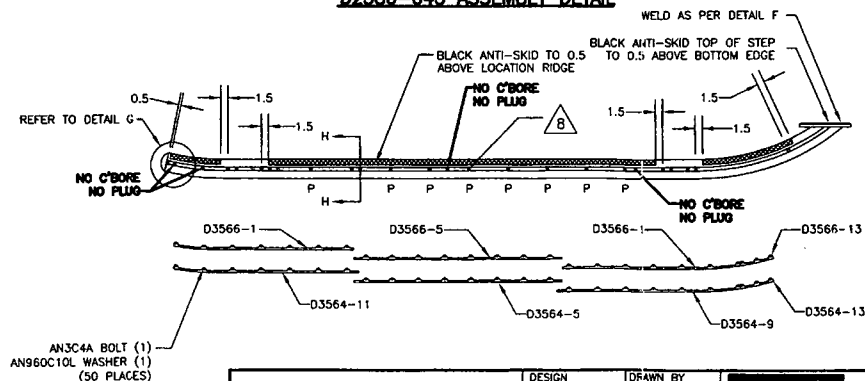
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	REV. 0
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2580	SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>R</i>	APPROVED <i>MP</i>		DE APPR. <i>#</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

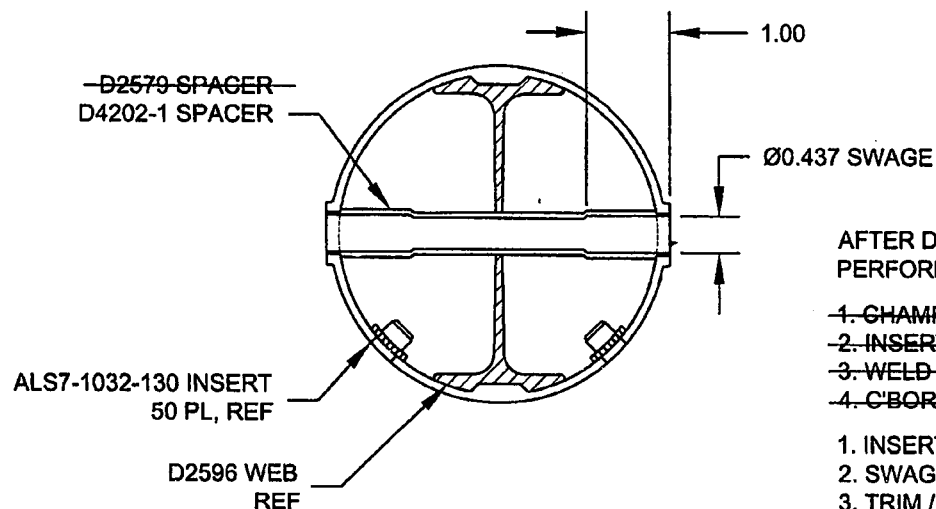
WAS

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-045		
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

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2010-11-18
MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries